

5/42

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	24401
<b>Description:</b> Bushing	<b>Part Number:</b>	D2617-5
<b>Dwg:</b> D2617 Rev. D1 D2	<b>Qty:</b>	50
05.10.03 <i>Posing</i>		Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	<i>HJ</i>	05.10.04	50
2	MC	Machine as per Folio FA438 and Dwg D2617 Material: 6061-T6 (QQ-A-225/8 or QQ-A-200/8 or WW-T-700/6) Ø0.500" tubing x 0.058" wall (M6061T6T0.500W.058) Identify as D2617-5 Batch: <u>M18740</u>	<i>S.G.</i>	05/10/27	50
3	QC2	Inspect parts as they come off the CNC machine	<i>S.G.</i>	05/10/27	50
4	QC8	Second check	<i>BB</i>	05.10.28	50
5	GA	Deburr break all unmarked sharp edges 0.005 to 0.010	<i>S.G.</i>	05/10/28	50
6	FP	Acid Etch and Alodine as per QSI 005 4.1	<i>SAD</i>	05/11/17	50
7	QC3	Inspect work to Step 6	<i>CL</i>	05/11/24	50
8	ST	Identify and Stock <i>Loc: 49</i>	<i>CL</i>	05/11/24	50
9	AC	Cost / part: _____	<i>SUR</i>	05.11.25	50
10	DC	Close W/O Inspect Level 21	<i>LD</i>	05/11/25	50

Rev	Date	Change	Revised By	Approved
D	98.04.16	Re-Format	KB	
E	99.08.23	Re-format, added notes and inspection level	EC	
F	01.01.03	Re-format, made in-house	EC	
G	01.01.08	Updated material NCR 467	EC	
H	04.07.14	Reformat; added step 5	KJ/JLM	<i>[Signature]</i>

RELEASED

*[Signature]* 05.07.14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: DP Date: 05/01/25

NOTE: Date & initial all entries

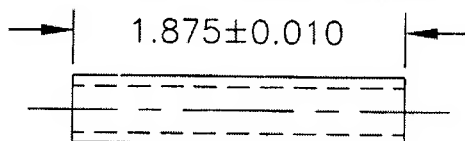
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_



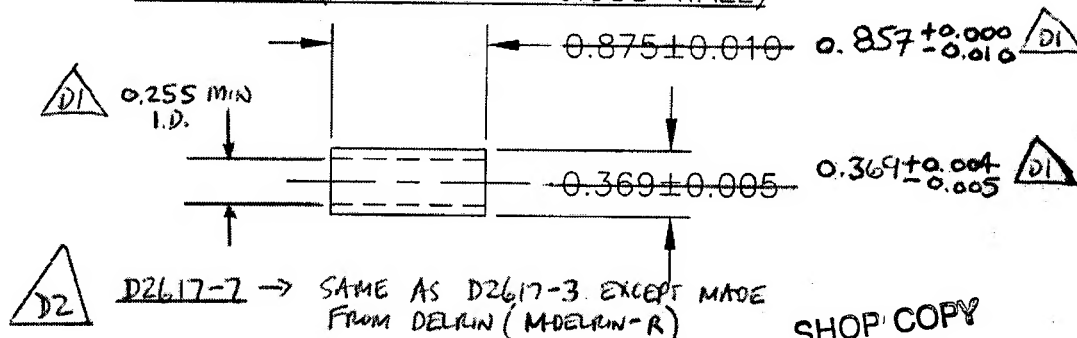


DESIGN		DRAWN BY		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
BW		CP			
CHECKED		APPROVED		DRAWING NO.	REV. D
#		#		D2617	SHEET 1 OF 1
DATE				TITLE	SCALE
01.07.04				BUSHING	1:1
A	96.10.08			NEW ISSUE	
B	97.05.08			.875 WAS 1.125	
C	97.06.04			0.369 DIA WAS 0.375	
D	01.07.04			ADD MAT'L SPEC AND TOL./DIM. NOTE	
DI	CP-#	04.07.12	CORRECT TOLERANCE (NCR 779)		

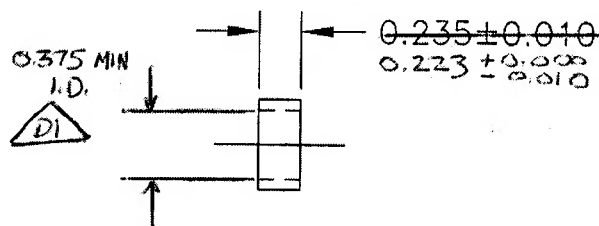
D2617-1 (0.375 OD x 0.058 WALL)



D2617-3 (0.375 OD x 0.058 WALL)



D2617-5 (0.500 OD x 0.058 WALL)



RELEASED  
01.07.05 #

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 24401

NOTES:

- 1) MATERIAL: 5052-H32 (QQ-A-225/7 OR WW-T-700/4)  
OR 6061-T6 (QQ-A-225/8, QQ-A-200/8, OR WW-T-700/6)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: ACID ETCH, ALODINE PER QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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# Job Costing Report

Dart Aerospace Ltd.  
Hawkesbury

Oct 03, 2005  
11:23 am

Work Order No : 0024401  
Project Name : D2617-5  
Project For : WK542  
Work Order Type : Main  
Main WO Number :  
House Part Number : D2617-5  
Description : Spacer  
Manufactured : Yes  
Amount Req'd : 50  
Amount Done : 0  
Start Date : 10-03-05  
Est Finish Date : 10-20-05  
Act Finish Date :  
Drawings Req'd : No  
Ok for Approval :  
Approval Rec'd :

Department Code:  
Burden Flags : NNNNNNNN  
WO Status : Open  
Invoice State : Not Invoiced  
Invoice Date :  
Invoice Number :  
Invoice Amount : 0.00  
Order Entry No :  
OE Value : 0.00  
Est Mark Up : 0.000%  
Actual Mark Up : 0.000%  
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00